

**CLAIMS:**

1. Device for the manufacture of cylindrical workpieces (1) which have a defined profiling, with an axially movable workpiece holder (2) intermittently rotatable about the longitudinal axis (Z) and forming tools (9) periodically acting on the workpiece (1), characterized in that at least one separate drive (11) mechanically separate from the drive (8) of the forming tools (9) is provided, which is connected with an electronic control which controls the intermittent rotational movement of the workpiece holder (2) in dependence of the drive (8) of the forming tools (9).
2. Device according to claim 1, characterized in that the forming tools (9) are profiled wheels or rollers (12), which are driven to continually rotate along a circular orbit (13), whereby the circular orbit (13) is, preferably adjustably, oriented parallel or obliquely to the longitudinal axis (Z) of the workpiece (1).
3. Device according to claim 1 or 2, characterized in that the workpiece holder (2) is supported in a headstock (20) guided and movable in parallel to the workpiece axis (Z) and connected with the separate drive (11) by way of a coupling (22) elastic in axial direction, whereby the separate drive (11) is preferably positioned in a secondary headstock (21) also guided and moveable parallel to the workpiece axis (Z).
4. Device according to one of claims 1 to 2, characterized in that the periodic movement of the forming tools (9; 12), the intermittent rotational movement of the workpiece holder (2), as well as the axial advancement of the workpiece holder (2) have separate drive units (4; 8; 11), which are electronically coupled with one another and preferably connected with the electronic control.
5. Device according to one of claims 1 to 4, characterized in that the workpieces (1) are cylindrical solid or hollow bodies.

6. Device according to one of claims 1 to 5, characterized in that the workpieces (1) are mounted on a cylindrical mandrel, which preferably has a profiled, preferably longitudinally profiled surface.
7. Method for the manufacture production of cylindrical workpieces (1) having a defined profiling with an axially movable workpiece holder (2) for the workpieces (1), which is intermittently rotatable about the longitudinal axis (Z), as well as forming tools (9) periodically acting on the workpiece (1), characterized in that the workpiece (1) is rotated about its longitudinal axis (Z) or stopped by way of an electronic control and a drive (11) separate from the forming tools (9) in dependence of the movement of the forming tools (9) for the generation of a predetermined defined profiling geometry on the workpiece (1).
8. Method according to claim 7, characterized in that the control imposes on the workpiece (1) left and right hand rotation as well as a standsill.
9. Method according to claim 7 or 8, characterized in that the control also controls the drive (8) and the advancement movement of the forming tools (9) according to preselected settings, as well as the axial advancement movement of the workpiece (1).
10. Use of a device according to one of claims 1 to 6 and/or use of the method according to one of claims 7 to 9 for the manufacture of helical toothings on cylindrical workpieces (1).